

Work Order ID 136580

Tuesday, October 13, 2015 1:07:18 PM

136580

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Item ID: D412-711-101

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Vertical Reference Window

Start Date: 8/26/2015 Start Qty: 2.00

2

Cust Item ID:

Required Date: 9/1/2015 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MLS Date: OCT 13 2015 Tooling: _____ Date: _____Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D412-711-101	B								

100 Document Control

100

DC

Doc.Control -USB or Paperwork

Memo

Photocopy bluefiles and create labels
for PPP D412-711-101 Change 062

110

110

HandThermo

Hand Finishing Thermoforming

HAND FINISHING THERMOFORMING

Memo

Set up Machine as per folio FTA 077 and D711W program using mould DT9640

0.00

0.01

DAS
07
9-89x2

120

120

HandThermo

Hand Finishing Thermoforming

HAND FINISHING THERMOFORMING

Memo

Cut Blanks to 37.5" by 43"

0.00

0.01

DAS
07
9-89x2

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Item ID: D412-711-101 Accept ***N900040100*** Setup Start ***NS1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	THERMOFORMING MACHINE	0.00							07 9-89
130						x2			
Thermoform	Memo	0.02							
Thermoforming Machine	Thermoform as per Dwg. D412-711-101 using DT 9640 and Folio FTA 077 Dwg. Rev. <u>B</u> Folio Rev. <u>B</u> Visually inspect for proper formation and clarity Visually and inspect magic eye Verified by: <u>SK</u>								
160	HAND FINISHING THERMOFORMING	0.00							DAS 07 9-89
160						x2			
HandThermo	Memo	0.04							
Hand Finishing Thermoforming	1) Trim off excess flange material blemishes 2) Buff out any light scratches or 3) Etch part number and batch number								

Pto

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☒ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐								
Date : <u>15-11-04</u>	Step #: <u>130</u>	QTY Effective : <u>2</u>		MRB (QSI042) Approval <u>A.P.</u> <u>15.11.04</u>						
Description Work Order Deviation Bubble window part wasn't correct they fix the mold to take out the time in it RC. part incorrect (mold)			Disposition <u>Scrap / destroy</u> <u>no replace</u> <u>fix the mold</u>							
Root Cause <table style="width:100%; border: none;"> <tr> <td style="width:50%; border: none;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☒ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:50%; border: none;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>			Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☒ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	FAULT CATEGORY <table style="width:100%; border: none;"> <tr> <td style="width:33%; border: none;"> Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:33%; border: none;"> Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> <td style="width:33%; border: none;"> Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☒ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐ </td> </tr> </table>			Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☒ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐
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OTHER : ☐			Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☒ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							

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[illegible]

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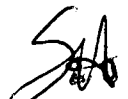
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Item ID: D412-711-101 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Replacement Vertical Reference Window
Start Date: 8/26/2015 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 9/1/2015 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: _____	0.00							
190									
Packaging	Memo	0.00							
Packaging	Location : FG099								
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

P.T.O.
SCRAP
151104

Picklist Print

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Work Order ID: 136580

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Parent Item: D412-711-101

D412-711-101

Parent Item Name: Replacement Vertical Reference Window

Start Date: 8/26/2015

Required Date: 9/1/2015

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 06-02-01 JLM
Manufacture in-house 10/06/28 DL

IPP Rev. B.

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MACRLICS.236		Purchased	No				sf	302.7830		42.66667			DAS 07 9-89

MACRLICS 236

Plexiglass G 60" x 96" x .236"

Location

Loc Qty

Loc Code

therm

302.78296

~ M129447

0.59296

→ M131524

153

M132743

149.19

15/10/19

42.66666666 sq ft.

DART AEROSPACE LTD		Work Order:	136580
Description: Replacement Window		Part Number:	D412-711-101
Inspection Dwg: D412-711-101 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "				
Shape Definition				
Texture Retention				
Material imperfections such as bumps, cracks, voids, scratching				

Measured by:		Date:	
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.00	+/-0.030					
1.98	+/-0.030					
1.50	Min					
0.090	Min					
0.070	Min					
0.050	Min					
15.0	+/-0.5					

Measured by:		Date:	
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Audited by:		Date:	
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Preliminary Approval:		Date:	
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Rev	Date	Change	Revised by	Approved
B	10.10.08	New Issue	KJ	
C	13.06.03	Dimensions updated per Dwg Rev B	KJ	

